

Date: Thursday, 07/05/2009 10:55:40 AM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SHOULDER HARNESS KIT	
<b>Job Number</b> :	47785			
<b>Estimate Number</b> :	13048			
<b>P.O. Number</b> :		<b>Part Number</b> :	D350764011	
<b>This Issue</b> :	07/05/2009	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	N/A	
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	46870	<b>Drawing Revision</b> :	B	
	<b>Type</b> :	<b>Material</b> :		
	PURCHASED PARTS	<b>Due Date</b> :	07/05/2009	<b>Qty:</b> 1 <b>Um:</b> Each
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :	MF 09-05-07			
<b>Comment</b> :	EST REV:A New issue 07-10-11 DD verified by EC Est Rev:B ECN 1050 rev.B as per dwg 08-01-10 DD			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D350-764-011

CHG001

2802/05/07

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3.0	D2854	3/4" Velcro Strip
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Comment: Qty.: 2.6660 f(s)/Unit Total: 2.6660 f(s)

3/4" Velcro

Cut qty 4 D2854-1-080 (8" each) as per dwg D2854

Batch: \_\_\_\_\_

4760451

4.0	D2854	3/4" Velcro Strip
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Comment: Qty.: 2.6660 f(s)/Unit Total: 2.6660 f(s)

3/4" Velcro

Cut qty 4 D2854-3-080 (8" each) as per dwg D2854

Batch: \_\_\_\_\_

B47604

5.0	D3578041	Doubler
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Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

DOUBLER

batch: B477143

9/6/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 47785

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3636041

Shoulder Harness



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SHOULDER HARNESS

batch B46198

9/5/17

SP

7.0

D3637041

Bracket Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BRACKET ASSEMBLY

batch B43353

9/5/17

SP

8.0

D36373

Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BRACKET

batch B43184

9/5/17

SP

9.0

D36381

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BUSHING

batch 45846

9/5/17

SP

10.0

D36391

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DOUBLER

batch B35128

9/5/17

SP

11.0

D36392

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DOUBLER

batch B42299

9/5/17

SP

12.0

D36393

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DOUBLER

batch B35382

9/5/17

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D36394

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DOUBLER

batch 1335383

9/5/7

SP

14.0

D36401

Belt Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BELT GIUDE

batch 1346656

9/5/7

SP

15.0

D36403

Belt Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BELT GIUDE

batch 1346657

9/5/7

SP

16.0

D36411

Cover



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

COVER

batch 1345827

9/5/7

SP

17.0

D36413

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

COVER

batch 1343232

9/5/7

SP

18.0

D36414

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

COVER

batch 1345497

9/5/7

SP

19.0

D36421

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

DOUBLER

batch 1343234

9/5/7

SP

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D36431

Stiffener



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STIFFENER

batch 1334547

9/5/7

SP

21.0

D36432

Stiffener



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STIFFENER

batch 1334548

9/5/7

SP

22.0

D36441

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SHIM

batch 1335392

9/5/7

SP

23.0

D36571

Guide Tool



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GUIDE TOOL

batch 1334550

9/5/7

SP

24.0

ALS41032130

Insert



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Insert

batch 1110511

9/5/7

SP

25.0

AN33A

Bolt



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

batch 111193

9/5/7

SP

26.0

AN36A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch 11109752

9/5/7

SP

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Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch

M104986

9/5/1

SP

28.0

AN960JD10

Washer



Comment: Qty.: 48.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

batch

M110985

9/5/1

SO

29.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M110363

9/5/1

SP

30.0

AN960JD616

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M111193

9/5/1

SP

31.0

AN9706

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M109488

9/5/1

SP

32.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Cherry Rivet

batch

M111548

9/5/1

SP

33.0

CR321242

Cherry Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cherry Rivet

batch

M11080C

9/5/1

(K)

SP

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Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

CR3212504

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch

M100321

9/5/17

SP

35.0

CR3212507

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch

M105978

9/5/17

SP

36.0

MS20426AD33

Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet

batch

M7681

9/5/17

SP

37.0

MS20426AD44

Rivet



Comment: Qty.: 106.0000 Each(s)/Unit Total : 106.0000 Each(s)

Rivet

batch

M15541

9/5/17

SP

38.0

MS20426AD46

Rivet



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Rivet

batch

M105144

9/5/17

SP

39.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet, Universal Head

batch

M109371

9/5/17

SP

40.0

MS21059L3

Nut Plate



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut Plate

batch

M109962

9/5/17

(R)

SP



## Process Sheet

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Job Number: 47785

Part Number: D350764011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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41.0	MS21072L3	Nutplate
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nutplate

batch

M110002

9/5/4

SP

42.0	MS35206267	Screw
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Screw

batch

M109389

9/5/4

SP

43.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

09/05/07

44.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-764-011

Location:

PPP Rev:

Rev B

09/05/07

45.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/05/07

Job Completion



MF  
09-05-07